

Work Order ID 135210 -2

Tuesday, August 04, 2015 11:07:22 AM

135210

Page 1

Item ID: D4092-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step Assembly

Start Date: 8/4/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 15-8-4

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

2

FF

AUG 17 2015

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in- lbs

2

FF

AUG 17 2015

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(2)

DAS
38

AUG 18 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval										
Description Work Order Deviation				Disposition				Completed By									
								Lead hand / Supervisor Approval Verification									
								QC / QA Coordinator Approval									
Root Cause		FAULT CATEGORY															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐																

135210

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/4/2015 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 8/7/2015 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Machining								

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

PPP 135189 2x

② JA

~~AUG 18 2015~~

DAS
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS AUG 18 2015

ML5

AUG 18 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, August 04, 2015 11:07:21 AM

Page 1

3

Work Order ID: 135210

135210

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 8/4/2015

Required Date: 8/7/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No				Each	2.0000		8			
				134870					**		FF	AUG 17 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST450				2					
				132452				2		2			
D4093-1 *D4093-1* Bracket		Manufactured	No				Each	8.0000		4			
									**		FF	AUG 17 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST449				8					
				128242				8		3+1			
D4093-3 *D4093-3* Bracket		Manufactured	No				Each	9.0000		4			
									**		FF	AUG 17 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST449				9					
				128243				9		3+1			
D4093-5 *D4093-5* Bracket		Manufactured	No				Each	0.0000		8			
									**		FF	AUG 17 2015	
				B124162 B135209						1 2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Tuesday, August 04, 2015 11:07:22 AM

Page 2

Work Order ID: 135210

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

135210

D4092-042

Start Date: 8/4/2015

Required Date: 8/7/2015

Start Qty: 4.00

Required Qty: 4.00

MS24694-S54

Purchased

No

Each

30.0000

8

MS24694-S54

SCREW

**

FF

AUG 17 2015

Location

Loc Qty

Loc Code

ST289

30

m130388

6

m132344

24

Each

156.0000

32

MS24694-S55

Purchased

No

MS24694-S55

Screw

**

FF

AUG 17 2015

Location

Loc Qty

Loc Code

ST289

156

m127305

3

m131624

53

m132803

100

Each

115.0000

8

MS24694-S56

Purchased

No

MS24694-S56

SCREW

**

FF

AUG 17 2015

Location

Loc Qty

Loc Code

ST289

115

m128402

17

m132344

98

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID: 135210

135210

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 8/4/2015

Required Date: 8/7/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

Each

2,452.000

48

NAS1149D0332.J

FF

AUG 17 2015

Washer

Location

Loc Qty

Loc Code

CA	14	
m129682	14	
GA	650	
m132677	650	
ST269	1788	
m130325	900	
m131624	54	
<u>m132677</u>	834	

48

MS21042L3

Purchased

No

Each

1,275.000

48

MS21042L3

FF

AUG 17 2015

Nut

Location

Loc Qty

Loc Code

FP001	393	
M130922	393	
GA	315	
M131317	315	
ST305	567	
116549	12	
126333	49	
M128754	2	
M132123	17	
M132382	4	
M132883	483	

48

Tuesday, August 04, 2015 11:07:22 AM

Shop Packet Print

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DQA: _____ Date: _____



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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																